

Date: Tuesday, 29/07/2008 9:02:19 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD BLADE FOLD ASSY WELDMENT
Job Number	: 40771		
Estimate Number	: 13418		
P.O. Number	:	Part Number	: PB674300107
This Issue	: 29/07/2008 S.O. No. :	Drawing Number	: B6743001 P.5
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 05/08/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>mf 08-07-29</u>		
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300147	Base Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 Base Assembly  
 batch: 340506

08-07-31 3

2.0	PB6743001205	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 Outer Tube  
 batch: 340776

08-07-31 3

3.0	PB6743001197	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 Outer Tube  
 batch: 340778

08-07-31 3

4.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)  
 Square Tubing  
 batch: 340593 340596

08-07-31 3

5.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 Square Tubing  
 batch: 340595

08-07-31 3

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Part Number: PB674300107

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PB6743001201	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Square Tubing  
batch:- 340592

*PK* 08.07.31 3

7.0	PB6743001203	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Square Tube  
batch:- 340594

*PK* 08.07.31 3

8.0	PB6743001207	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Square Tube  
batch:- 340593

*PK* 08.07.31 3

9.0	PB6743001219	Angled Male Eye
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Angled Male Eye  
batch:- 324003

*PK* 08.07.31 3

10.0	D34405	Contoured Detent Clip Base
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Contoured Detent Clip Base  
batch:- 324002

*PK* 08.07.31 3

11.0	D34407	Detent Clip Base
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Detent Clip Base  
batch:- 324004

*PK* 08.07.31 3

12.0	D344015	Contoured Male Eye
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Contoured Male Eye  
batch:- 324074

*PK* 08.07.31 3

*PK*

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Part Number: PB674300107

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8813 and weld as per dwg PB67-43001

\*\*\*ensure no burn thru after welding in tube 205 and 197\*\*\*

*weld base of frame as per  
dwg. 3# 42506*

*08-08-07 3*

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 08-08-08 (3)*

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/08/08 (X2)*

16.0

POWDER COATING

POWDER COATING



*M102316*



*(3X)*

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

*10:30*

OVEN TEMPERATURE:

*320 °F*

FINISH TIME:

*11:00*

*M.A. 08/08/11*

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08-08-11*

*(X3)*

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Pat F.*

*MF. 08-08-26*

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/08/27*

Job Completion



*MF 08-08-26*

RELEASED  
JUL 20 1962

